

-212

Dart Aerospace Ltd.

Date: Tuesday, 22/04/2008 10:25:13 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B  
 Job Number : 38719A  
 Estimate Number : 10163  
 P.O. Number :  
 This Issue : 22/04/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : LANDING GEAR  
 Previous Run : 38718A  
 Part Number : D206642241  
 Drawing Number : D2650 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material :  
 Due Date : 12/05/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.4.22  
 Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D206-642-241

CHG003

N/A

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD

B32449

DP 8-4-23

3.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler

B33875

DP 8-4-08

4.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap

B35475

BE 08-04-25

5.0 SKIDTUBES 1 SKIDTUBE RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

DP 8-4-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 38719A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

DP 8-4-23

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod m/06330/m/07263 BE 08-04-25

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

) W 8-4-28

15-C'sink GHW rivet holes as per Dwg D2650

84-28

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

808/0429

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Seq. #: Machine Or Operation: Description :

7.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

8-4-29

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-4-29

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8-4-29

10.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

8-4-29

11.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/04/08

12.0 CR3212404 Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet 107715

SL 8-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 38719A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D26543

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2654-3 Web 37764

SL 8-4-29

14.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 8-4-29 Time: 3:30 pm

Finish Date: 08-04-30 Time: 7:30 am

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 107804

Sikaflex expire date: 8-7-31

SL 8-4-29

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

208-04-30 @

16.0

D2649

Cross Bolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649 Crossbolt spacer 337859

BE 08/05/07

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer 337783

BE 08/05/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38719A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M107877 BE 08/05/07

2-Grind welds flush as per Dwg D2650. SL 8-5-7

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 08/05/15

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

*(Handwritten signature)*

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets 107707 SL 8-5-20

*(Handwritten mark)*

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets 102515 SL 8-5-20

*(Handwritten mark)*

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch


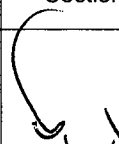


1 D2680-041 Nut Plate 34599 SL 8-5-20

*(Handwritten mark)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-241 PAR #: N/A Fault Category: Prod / X-Tubes NCR: Yes No DQA: D Date: 08/06/07  
 QA: N/C Closed: D Date: 08/06/07

NCR: 38719A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-05-07	18.0	Find: Aft x-bolt spacers were found to be not centered, after welding. <del>R.C. - Drilled to one side during welding, and drilled (back drilled) off center. Original holes drilled, were not centered when opened up.</del>	 Q251112	Remove x-bolt spacer @ fwd: Aft saddle locations. replace x-bolt spacers Qty 8 B 37859, and weld as per dwg: 051004 A/R M107877	BE 08/05/13	 08/05/16	 1025112	 10805-07

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Job Number: 38719A

Part Number: D206642241

Job Number:



Seq. #: Machine Or Operation: Description :

22.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

SL 8-5-20

23.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 08-05-20

24.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/20 @

25.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

RB / BK 08-05-20 30 min

26.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

M107925

21/05/2008  
S.265 08.55  
#1 320.0 F  
#2 B38719A  
#3  
#4 D206642241 F

m-l 08/05/2

27.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/05/21 @

28.0 D26483 Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
4 D2648-3 Wearpad B34591

FL

29.0 D265613 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2656-13 Wearshoe B35542

FL 08/05/22 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38719A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B37101

*FL*

31.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B29452

*FL*

32.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B39609

*FL*

33.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

or (see QSI 017)

m/05819

*FL*

34.0

AN960JD10L

Washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

46 AN960JD10L

Washer

m/09885

*FL 08/05/22①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38719A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

MS27039108

Screw



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

46 MS27039-1-08

Screw

m107378

FL

36.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-1

Plugs

B38273

FL

37.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-3

O-Rings

B36141

FL

38.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS27039-4-06

m106541

FL

39.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN960JD416

Washer

m105426

FL

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

m107804

FL 08/05/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38719A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date: 08/10

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

FL 08/05/22

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap

037377

FL

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

m107804  
08/10

> FL 08/05/22 (1)

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: m107892

217/m.p

08/05/22 (1x)

43.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/05/22 (1x)

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/22 (1x)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206664241 IF APPLICABLE

Location:

PPP Rev:

PPP 38219

8/6/18

SEP

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*cu 08.06.18*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**DART**RELEASED  
16 04 17

DESIGN 11P	DRAWN BY 11P	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 11P	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

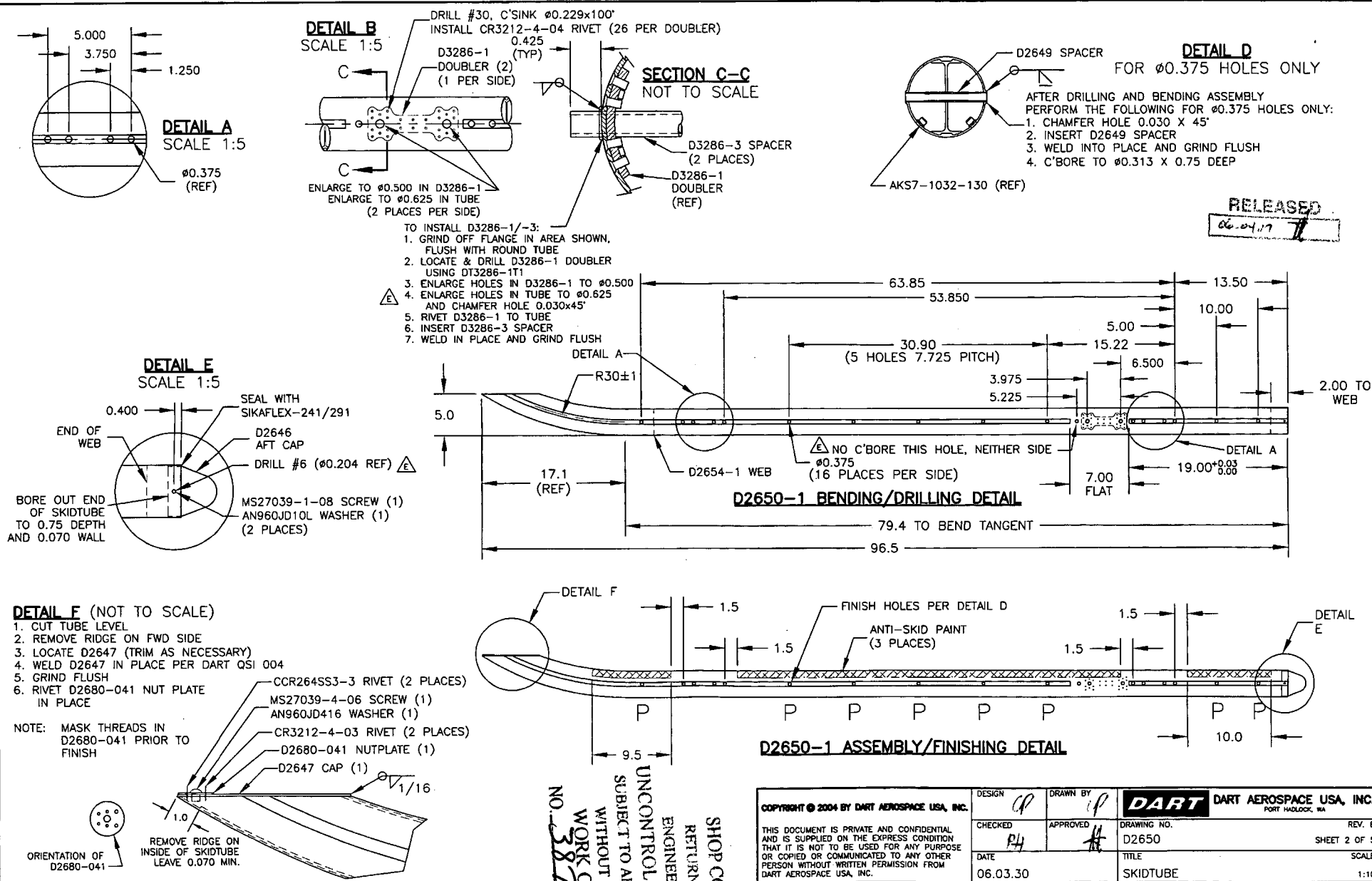
**NOTES**

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH:  
-CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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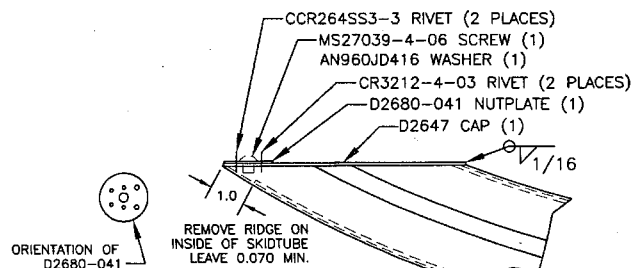
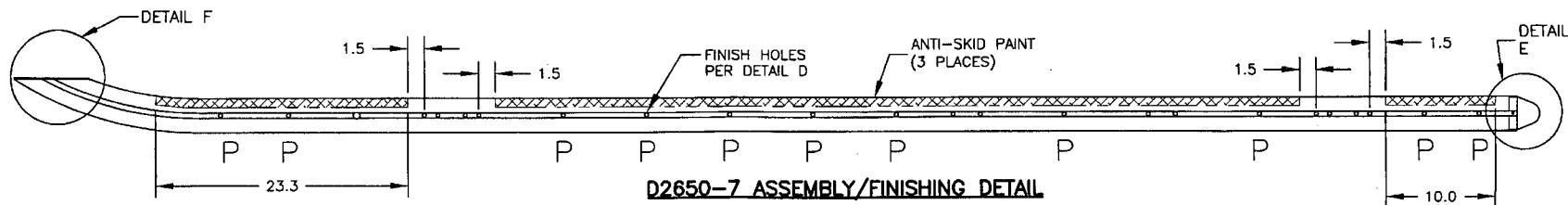
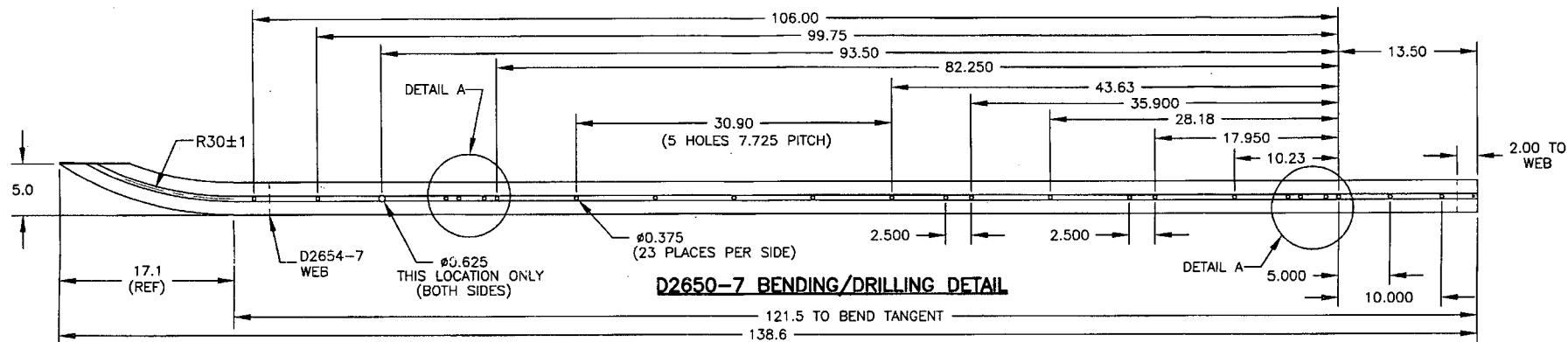
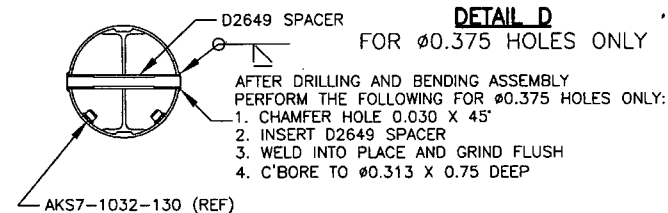
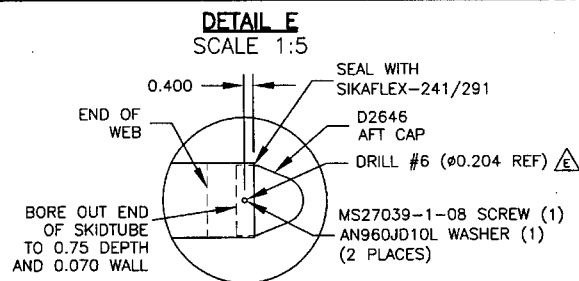
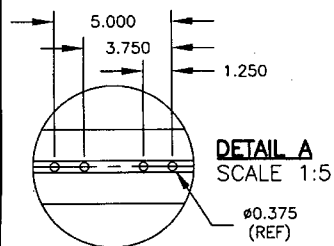
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**DETAIL F (NOT TO SCALE)**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUTPLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	APPROVED	DRAWING NO. D2650
DATE		TITLE SKIDTUBE
06.03.30		SCALE 1:10

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NO. 155

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 369629  
Part number: D206 642 641  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[☒] fail[ ]

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier Pat Duval Date of Test Coupon 08-05-09  
Welder Barclay Elliot Date of Test Coupon 08-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld